

Date: Monday, 10/30/2006 7:40:44 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 29200
 Estimate Number : 10423
 P.O. Number : *NIA*
 This Issue : 10/30/2006 S.O. No. : *NIA*
 Prsht Rev. : NC
 First Issue : *NIA* Type : SMALL /MED FAB
 Previous Run : 28126
 Written By : *[Signature]*
 Checked & Approved By : *[Signature] 06 10 30*
 Comment : Est:A 04.09.07 New issue KJ/JLM

Drawing Name : HEAD REST

Part Number : D33033
 Drawing Number : D3303 REV. B
 Project Number : N/A
 Drawing Revision : B
 Material : *NIA*
 Due Date : 11/20/2006

Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.3135 sf(s)/Unit Total : 3.1353 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: *M102448*

2.0 WATER JET FLOW WATER JET



Dwr *B*
 Prog *B*



Comment: FLOW WATER JET

SB 06-11-05

(10)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SB 06-11-06

(10)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SB 06/11/06

(10)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

2- C'sink nut plate holes as per Dwg D3303

SB 06-11-09

10

SB 06/11/15

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/30/2006 7:40:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAD REST

Job Number: 29200

Part Number: D33033

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3303

SB 06/11/14 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20-11-20 (8)

(PTO)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

4/ 06/11/22 X P

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

FF 06-11-23 8

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ST422

BOOK

B 06/11/23 (2)
SB 06/11/23 6

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(6)
06/12/04

Job Completion



U 06.11.23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-11-20	5.0	debur : Polish water Jet marks. Permanent change	EE	06/12/04		JB 06/12/04	JB 06-11-20

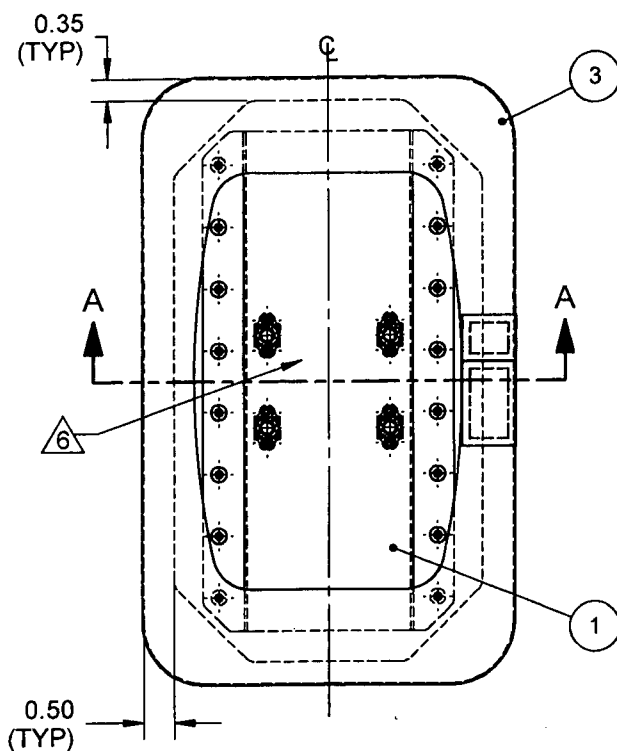
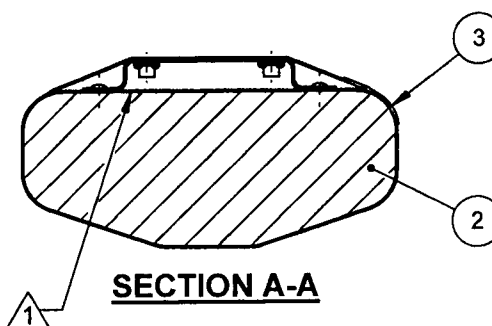
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 04/12/04
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-11-20	7.0	Entered on cross A + seq. 6.0. 2 parts had slight blasting marks from the water Jet, and caused the material to crack during bending.	JB 06/11/20	Scrap: destroy. Remove W.J. marks during deburring.	SB 06/11/20	JB 06-11-20	JB 06-11-20	JB 06-11-20

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 1 OF 4
DATE 06.08.17	TITLE HEAD REST		SCALE 1:3
REV	DATE	DESCRIPTION	
A	04.08.18	NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	

**RELEASED***dc-09.19***D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

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WORK ORDER
NO. 29200

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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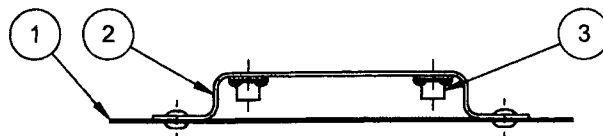
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 2 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

INSTALL ITEM ⑤
MS20470AD4-4 RIVETS
(16 PLACES)

MASK THREADS
PRIOR TO PAINT
(4 PLACES)

INSTALL ITEM ③
MS21075L3 NUT PLATE (1)
USING ITEM ④
MS20426AD3-3 RIVET (2)
(4 PLACES)



D3303-043 BRACKET ASSEMBLY

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

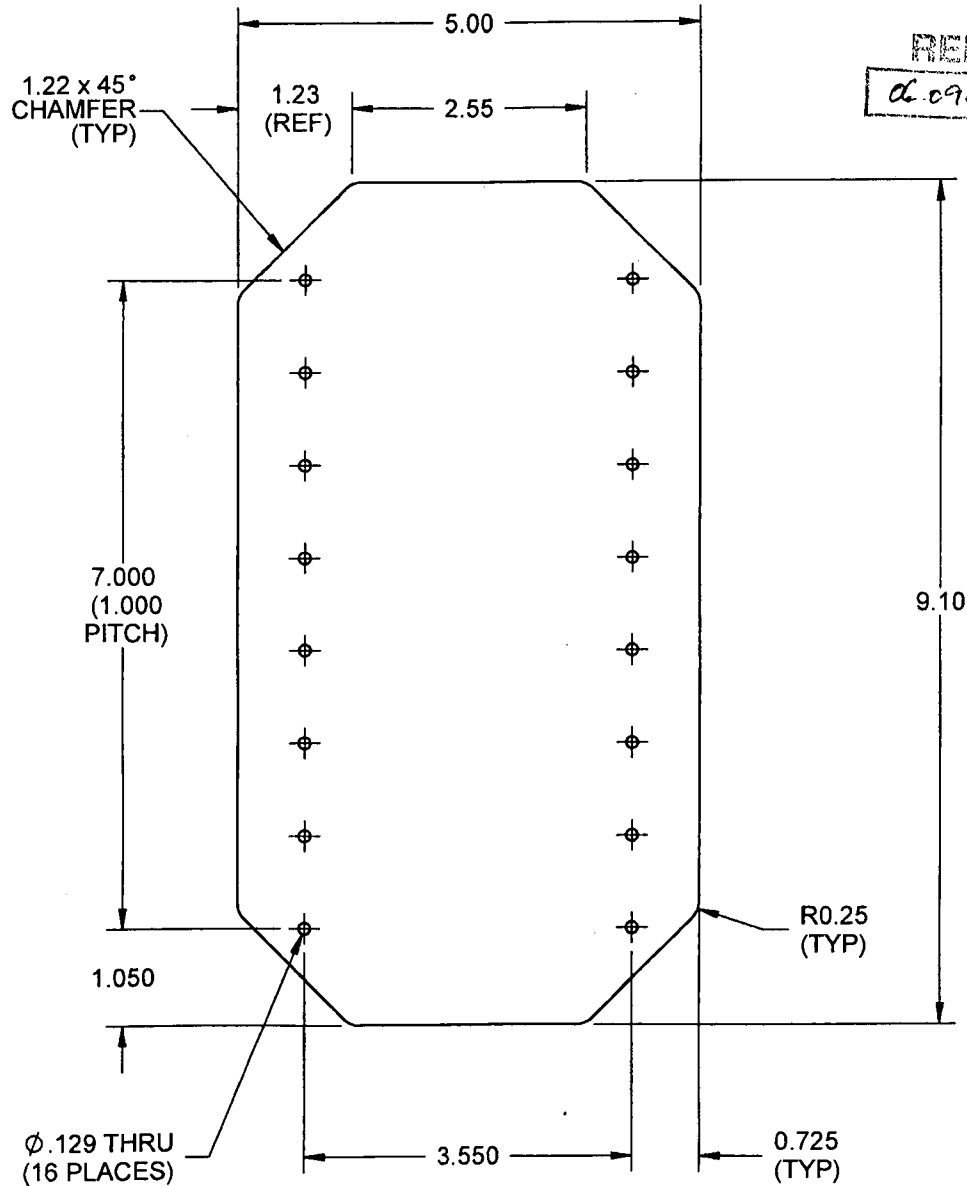
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CHECKED <i>PH</i>	APPROVED <i>AB</i>	DRAWING NO. D3303	REV. B SHEET 3 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

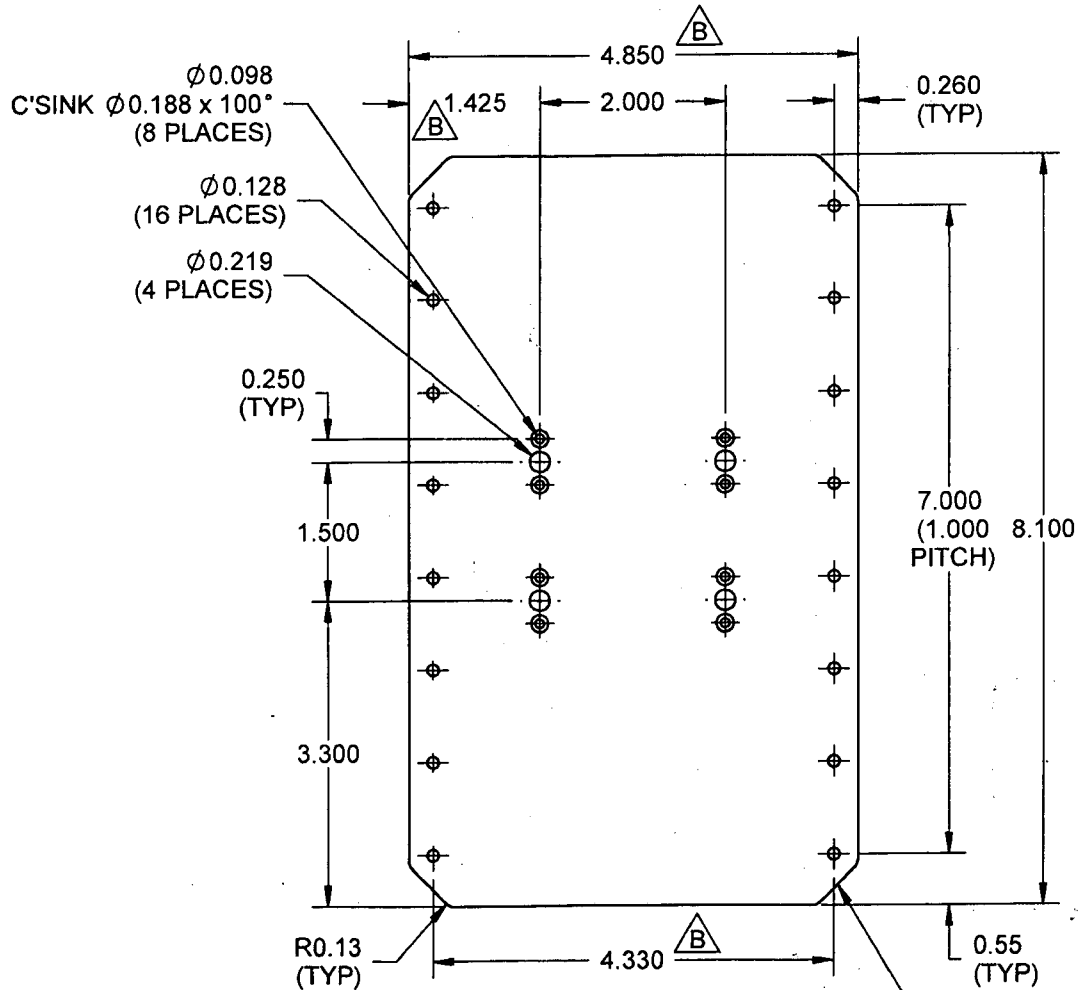
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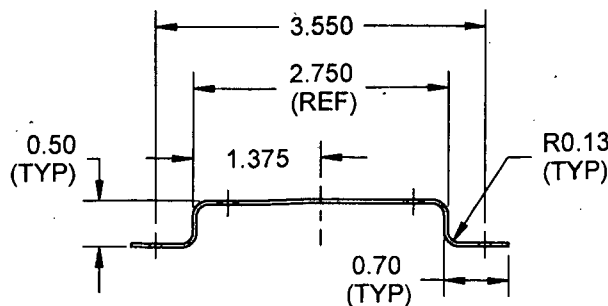
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CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3303	REV. B SHEET 4 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



D3303-3F BRACKET FLAT PATTERN

RELEASED
06.09.19

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WORK ORDER
NO. **29200**



D3303-3 BRACKET BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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DART AEROSPACE LTD		Work Order: 29200
Description:		Part Number: 092033
Inspection Dwg:	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.128	+ 0.005 - 0.001	Ø 0.129	✓		Vern	
Ø 0.098	+ 0.004 - 0.001	Ø 0.100	✓		Vern	
Ø 0.249	+ 0.005 - 0.001	Ø 0.218	✓		Vern	
1.500	± 0.010	1.501	✓		Vern	
3.300	± 0.010	3.299	✓		Vern	
0.260	± 0.010	0.264	✓		Vern	
0.550	± 0.010	0.549	✓		Vertical Vern	
4.330	± 0.010	4.330	✓		Vern	
4.850	± 0.010	4.853	✓		Vern	
7.000	± 0.010	6.999	✓		Vern	
8.100	± 0.010	8.108	✓		Vern	
1.000	± 0.010	0.997	✓		Vern	
1.425	± 0.010	1.427	✓		Vern	
2.000	± 0.010	1.996	✓		Vern	
0.040	± 0.010	0.040	✓		Vern	

Measured by: JAD	Audited by: DD	Prototype Approval: N/A
Date: 06-11-04	Date: 06/11/06	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	